






# Work Order ID 52976

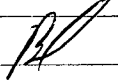


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Page 1

Item ID: D119-646-243 Accept  Setup Start   
Revision ID: B Stop   
Item Name: Replacement Float Skidtube w/ Training Wearplates  
Start Date: 20/10/2009 Start Qty: 1.00  Cust Item ID:  
Required Date: 02/11/2009 Req'd Qty: 1.00  Customer:

## Reference:

Approvals: Process Plan:  Date: 09/10/20 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3905	B								
IIN-D119-646	B								

100

0.00



DC

Document Control

## Memo

Photocopy bluefile & type labels per PPP D119-646-243  
CHG 001

0.00

N/A 

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Item ID: D119-646-243

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

**Memo**

0.00

1- Bend FWD end of tube using Bender 1 and bend prog D3905 FWD per dwg D3905

2- Cut FWD end of tube as per dwg D3905.

3- Cut AFT end of tube as per dwg D3905.

4- Buff out marks left from bending

5- Drill Aft cap pilot hole using DT8149 \*\*\*DO NOT OPEN TO FINISHED SIZE\*\*\*

6 -Cleco DT8149 in position and install drill Jig DT \_\_\_\_\_ drill X-bolt spacer pilot holes using 3/16" drill

7- Spot drill holes to section G using #30 drill.

8- Drill FWD cap holes using DT8215. Open FWD &amp; AFT capholes to 0.208"

9- Drill FWD holes

10- Drill Tow ring hole using DT \_\_\_\_\_. Open to finished size.

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Item ID: D119-646-243

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_






Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00							
130  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				1			 10-11-12
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				1			 10-11-12



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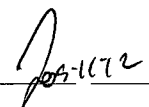
Page 4

Item ID: D119-646-243 Accept  Setup Start   
 Revision ID: B Stop   
 Item Name: Replace:ment Float Skidtube w/ Training Wearplates  
 Start Date: 20/10/2009 Start Qty: 1.00  Cust Item ID:  
 Required Date: 02/11/2009 Req'd Qty: 1.00  Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Skidtubes	<b>Memo</b> 1-Open crossbolt spacer holes to finished size ***DO NOT OPEN SPOT DRILLED HOLES IN SECTION G***  2-Deburr crossbolt spacer holes as per Dwg D3905 and blow out chips from inside the tube	0.00  0.00							
160  QC Quality Control	QC5- Inspect part completeness to step on W/O  <b>Memo</b>	0.00  0.00							

>

1   
 See attached  
 work instructions

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Item ID: D119-646-243

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009 Start Qty: 1.00



Curr Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

170

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Bond web in place as per Dwg D3905 & QSI 015.

A/R ☐ Sikaflex-291 ☒ 11/2/09 ☐ ☐

Sikaflex expire date: ☐ 10-2-10 ☐

Start: ☐ \_\_\_\_\_ Time: ☐ \_\_\_\_\_

Finish: ☐ \_\_\_\_\_ Time: ☐ \_\_\_\_\_

\*\*\*\*\* (Adhere for 12 hours) \*\*\*\*\*

2--Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Install drop pins in crossbolt spacer holes to maintain web position.

3- Buff out marks left from bending.

4- Open holes of section G (spot drilled holes) to finished size.

\*\*\*\*\*VERIFY DIMENSIONS\*\*\*\*\*

5- Countersink crossbolt spacer holes, and prepare tube for welding, deburr.

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Item ID: D119-646-243

Accept

Setup Start

Revision ID: B

Stop

Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

180

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

See attached work sheet  
Ref. only

190

0.00

Skid tubes

Memo

0.00

Skid tubes

1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3905. Remember to back drill each hole before welding the other side. Use aluminum rod A/R ☐ Aluminum Rod ☒ M112507 BE 09/11/16

2-Grind cross bolt welds flush as per Dwg D3905. Ensure no pin hole.

3-Counterbore 5/16" x 0.750" deep as per Dwg D3905.

4- Deburr & Scribe batch # on Aft end of tube.

09/11/16

9-11-17

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Item ID: D119-646-243

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 2) 8 or 11/17 0.00							
210  QC Quality Control	QC10- Inspect visual per QS1004- ground welds  Memo	0.00 2) 8 or 11/17 0.00							
220  HandFinish Hand Finishing	Pressure Wash per QS1005 4.3  Memo	0.00 2) 24 09/11/18 0.00							

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Item ID:	D119-646-243	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Replacement Float Skidtube w/ Training Wearplates					
Start Date:	20/10/2009	Start Qty:	1.00	Cust Item ID:		
Required Date:	02/11/2009	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M112148 Memo START: 10:30AM Temp: 320°F FIN: 11:00	0.00 0.00	⇒	09/11/18		(XL)			
240  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	BR 09-11-19			①			
250  HandFinish Hand Finishing	1-Install inserts as per Dwg D3905. Memo	0.00 0.00	BR 09-11-19			①			



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Item ID:	D119-646-243	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Replacement Float Skidtube w/ Training Wearplates					
Start Date:	20/10/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	02/11/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	275 09/11/19						
270  HandFinish Hand Finishing	Memo 1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers. A/R <input type="checkbox"/> Sikaflex-240/-291 <input checked="" type="checkbox"/> 11/12/2011 Sikaflex expire date: <input type="checkbox"/> 10/20 2- install plugs assembly as per dwg. 3 -Inspect for foreign objects as per QSI 024 4 -Install Aft Cap and seal with Sikaflex. Clean excess adhesive. A/R <input type="checkbox"/> Sikaflex-240/-291 <input checked="" type="checkbox"/> 11/12/2011 Sikaflex expire date: <input type="checkbox"/> 10/20	0.00 0.00	B/R 09-11-19.						

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Item ID:	D119-646-243	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Replacement Float Skidtube w/ Training Wearplates					
Start Date:	20/10/2009	Start Qty:	1.00	Cust Item ID:		
Required Date:	02/11/2009	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	2) 802/1/19						
285  HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch  Memo	0.00	11/12/2009 11-19						
286  QC Quality Control	QC5- Inspect Part Finish For Completeness on W/O QC5 6 Memo	0.00 0.00	2) 802/1/19						

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Item ID: D119-646-243

Accept



Setup Start



Revision ID: B

Stop



Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

290

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

PPD 51853

9/14/20 PDP

Packaging

300

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/25 AJ

MF  
09-11-20

# Picklist Print

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Page 1

Work Order ID: 52976

Parent Item: D119-646-243RevB

Parent Item Name: Replacement Float Skiddtube w/ Training Wearplates

Start Date: 20/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-1-190RevU/R		Manufactured	No			110	Each	0.0000	1.0000			
Ext'n -1' Beam Tube 4"												
D3885-3RevB		Manufactured	No			170	Each	1.0000	1.0000			
Standard Web												

				<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
				<u>Location</u>		
				Main Warehouse		
				ST	1	
				51844	1	
D3903-1RevB		Manufactured	No		190	Each
Spacer						

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	126	
51849	126	

12 BE 09/11/09

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Work Order ID: 52976

Parent Item: D119-646-243RevB

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates


Start Date: 20/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3681-1RevA		Manufactured	No			190	Each	89.0000	8.0000			
												
Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

20

51920

20

Main Warehouse

ST

69

47123

13

48178

56

\* D3683-3RevB

Purchased

No

250

Each

0.0000

12.0000



Insert

ALS4-1032-130

Purchased

No

250

Each

5,373.000

10.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5373

110511

5373

D2855-3RevB

Manufactured

No

270

Each

0.0000

2.0000



Cap

52 281

B se 09/11/09

12, 09-11-19

10 09-11-19

2 09-11-19

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Work Order ID: 52976

Parent Item: D119-646-243RevB

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3672-1RevB		Manufactured	No			270	Each	2,054.000	4.0000			
Phenolic Washer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1554	
39275	19	
42329	13	
47628 ✓	522	
52505	1000	
Main Warehouse		
ST117	500	
51674	500	

4 B102-11-19

D3846-1RevB

Manufactured No

270

Each

10.0000

1.0000

GASKET

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	10	
51827 ✓	10	

1 B102-11-19

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Work Order ID: 52976

Parent Item: D119-646-243RevB

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates


Start Date: 20/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3846-11RevB		Manufactured	No			270	Each	20.0000	1.0000			
												
GASKET												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

20

51833 ✓

20

D3847-1RevB

Manufactured

No

270

Each

35.0000

1.0000



WEARPAD

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

35

51823 ✓

35

D3847-11RevB

Manufactured

No

270

Each

19.0000

1.0000



WEARPAD

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

19

51824 ✓

19

D3849-047RevB

Manufactured

No

270

Each

0.0000

1.0000



WEARPLATE

51837

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Shop Packet Print

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Work Order ID: 52976

Parent Item: D119-646-243RevB

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3849-045RevB		Manufactured	No		51836	270	Each	0.0000	1.0000		1	BR09-11-19

AFT WEARPLATE ASSY, FLOATGEAR

D3904-1RevB

Manufactured No

270

Each

300.0000

16.0000

Washer

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST136

51875

300

300

270

Each

659.0000

12.0000

D3672-3RevB

Manufactured No



Phenolic Washer

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

34471

48258

159

8

151

Main Warehouse

ST117

51596

500

500

16 BR09-11-19.

12 BR09-11-19.



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Work Order ID: 52976

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Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009 Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C5A  Bolt		Purchased	No			270	Each	714.0000	14.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	714	
111424	8	
111707	69	
112314	7	
112489	100	
112641✓	500	
112720	30	

14 BR 02-11-19

AN3C46A



BOLT

Purchased

No

270

Each

93.0000

4.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	93	
106169	5	
106176	9	
111918✓	79	

4 BR 02-11-19

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Parent Item: D119-646-243RevB

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates


Start Date: 20/10/2009

Required Date: 02/11/2009

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			270	Each	5,216.000	10.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	5116	
112116	926	
1126121 ✓	3190	
112933	1000	

10 BR 09-11-19.

AN960C416



washer

Purchased

No

270

Each

703.0000

12.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	703	
100993 ✓	703	

12 BR 09-11-19.

# Picklist Print

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Work Order ID: 52976

Parent Item: D119-646-243RevB

Parent Item Name: Replacement Float Skidtube w/ Training Wearplates


Start Date: 20/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-3  Nut		Purchased	No			270	Each	5,119.000	8.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	80	
103691	80	
Main Warehouse		
ST	5039	
111819	78	
112243	39	
112314 ✓	4922	

MS27039C4-08

Purchased

No

270

Each

117.0000

12.0000



SCREW

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	117	
178311 ✓	117	

8 BL 09-11-19

12 BL 09-11-19

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Work Order ID: 52976



Parent Item: D119-646-243RevB



Parent Item Name: Replacement Float Skidtube w/ Training Wearplates

Start Date: 20/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3C50A

Purchased

No

270

Each

78.0000

4.0000



Bolt

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

78

112046

5

112454 ✓

23

112761

50

4 BR 09-11-19.

D3411-3RevREVA

Manufactured

No

270

Each

90.0000

16.0000



WASHER

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

90

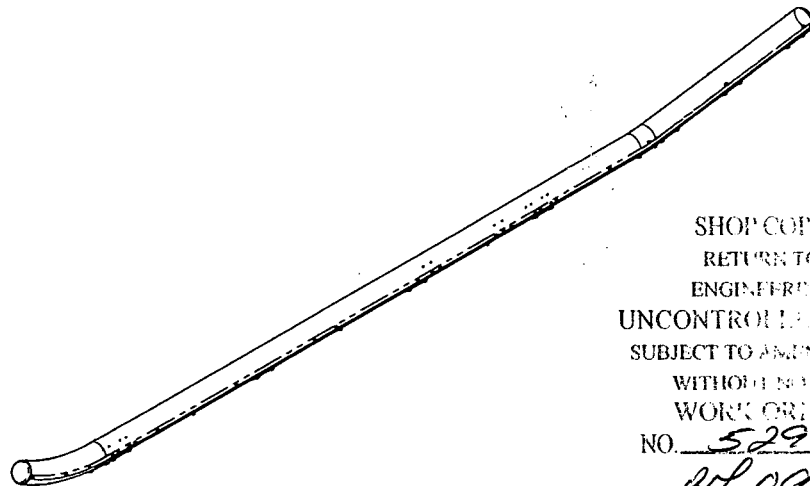
51635 ✓

50

52597

40

16. BR 09-11-19.



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*BT 09-10-20*

**D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)**  
**D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)**  
**D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)**

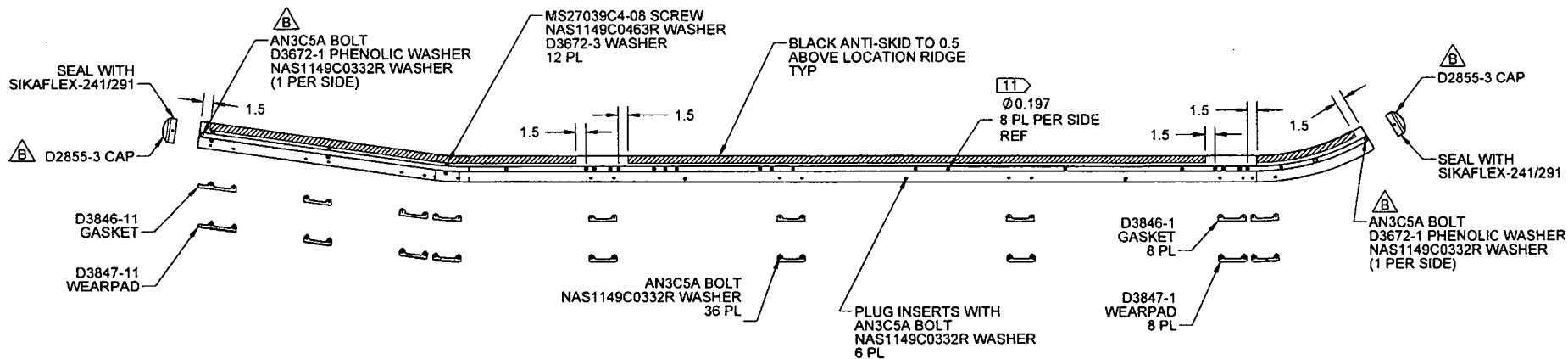
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-3 FLOAT WEB  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3905-041 = 40.7 lbs  
D3905-043 = 47.0 lbs  
D3905-045 = 47.3 lbs
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
- 11) INSERT D3492-045 PLUG ASSY INTO Ø0.197 HOLES (BOTH SIDES OF TUBE)
- 12) USE DART DRILL TEMPLATE DT8932 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARPLATE INSERTS. INSTALL AELS-1032-130 INTO D3905-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/-291.

ITEM	QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION
1	X			D3905-041	FLOAT SKIDTUBE ASSY WITH WEARPAD
2		X		D3905-043	FLOAT SKIDTUBE ASSY WITH WEARPLATE
3			X	D3905-045	FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE
11	2	2	2	D2855-3	CAP
12	16	16		D3492-045	PLUG ASSY
13	4	4	4	D3672-1	PHENOLIC WASHER
14	8	8	8	D3681-1	SPACER
15	8	1	1	D3246-1	GASKET
16	1	1	1	D3846-11	GASKET
17	8	8	1	D3847-1	WEARPAD
18	1	1	1	D3847-11	WEARPAD
19		1		D3847-043	FWD WEARPLATE ASSY
20		1		D3847-045	CENTER WEARPLATE ASSY
21		1		D3847-049	AFT WEARPLATE ASSY
22			1	D3849-047	FWD WEARPLATE ASSY
23			1	D3849-045	AFT WEARPLATE ASSY
24	1	1	1	D3885-3	FLOAT WEB
25	1	1		D3905-11	FLOAT SKIDTUBE
26			1	D3905-13	FLOAT SKIDTUBE
27	12	12	12	D3903-1	SPACER
28			16	D3904-1	WASHER
29	12	12	12	D3672-3	WASHER
30	12	12	12	D3683-3	INSERT
31			16	D3411-3	WASHER
41	42	42	10	ALS4-1032-130	INSERT
42	46	46	14	AN3C5A	BOLT
43			4	AN3C48A	BOLT
44			4	AN3C50A	BOLT
45	46	46	10	NAS1149C0332R	WASHER (OR AN960C10L)
46	12	12	12	NAS1149C0463R	WASHER (OR AN960C416)
47			8	MS21043-3	NUT
48	12	12	12	MS27039C4-08	SCREW

RELEASED  
09/15/14

B	REVISED PART LIST. ALS4-1032-130 WAS AELS-1032-130 (ZN A6-5, A5-6, C6-7, A5-7); ADD DT8932 (ZN A8-1); D2855-3 WAS D2875 (ZN C8-2, C1-2, C8-3, C1-3, C8-4, C1-4); AN3C5A WAS AN3C4A (ZN C7-2, C1-2, C7-3, C1-3, C7-4, C1-4); D3849-047 WAS D3849-041 (ZN B3-4); ADD D3411-3 (ZN B3-4); ADD AN3C50A (ZN B3-4); Ø0.313 WAS Ø0.328 (B2-5, B2-6, C2-7, A8-7 & D7-8); REVISED NOTE 14 (ZN A8-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
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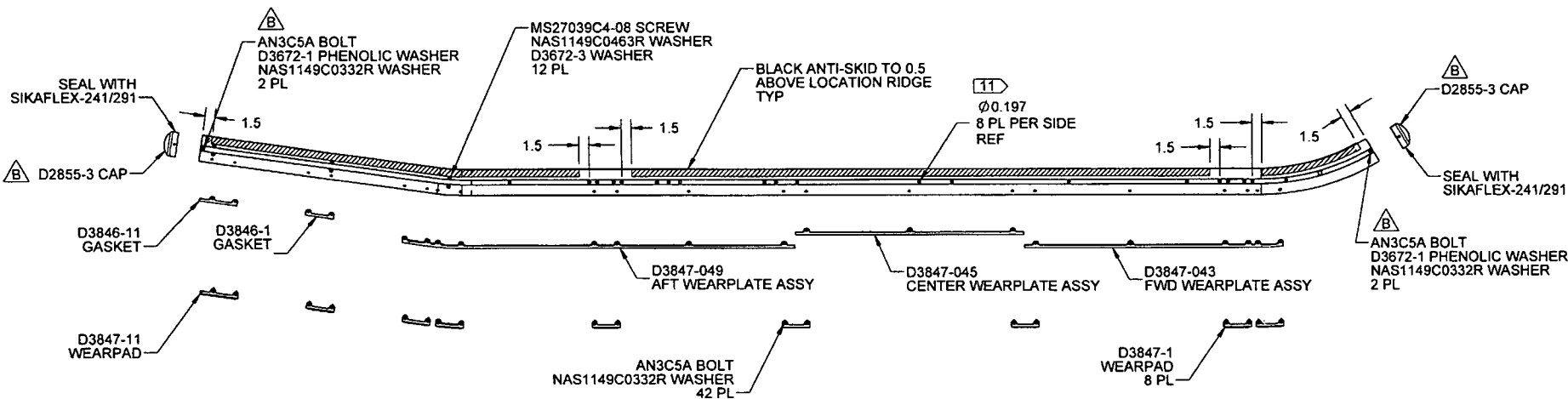


**D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD**  
(MAKE FROM D3905-11 SKIDTUBE)

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10/15/14

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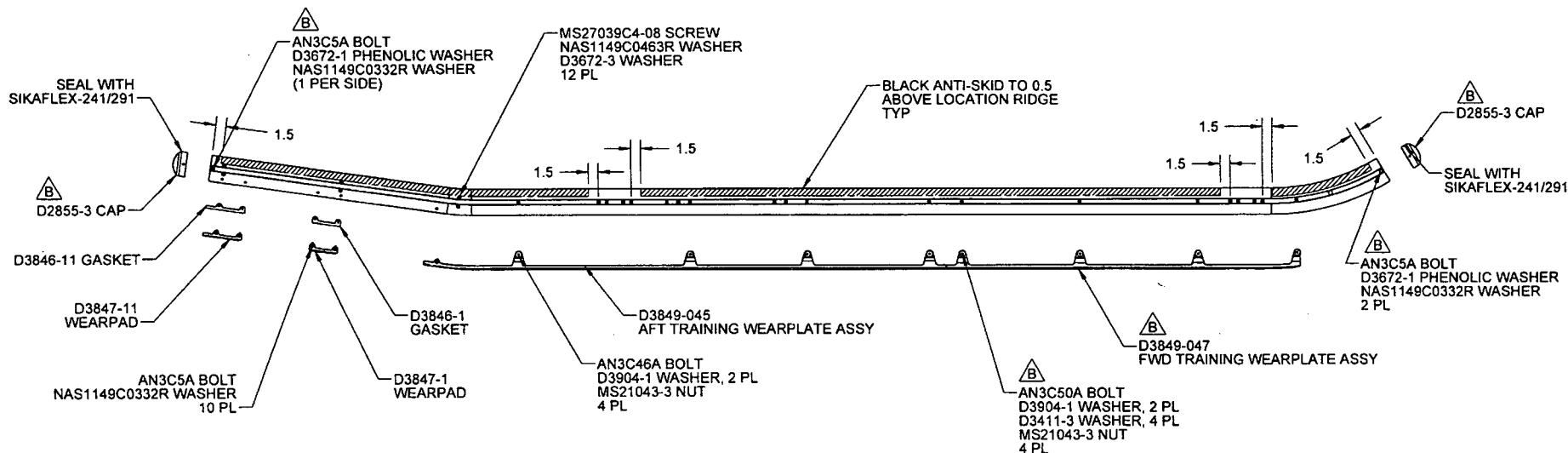


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**D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE**  
(MAKE FROM D3905-11 SKIDTUBE)

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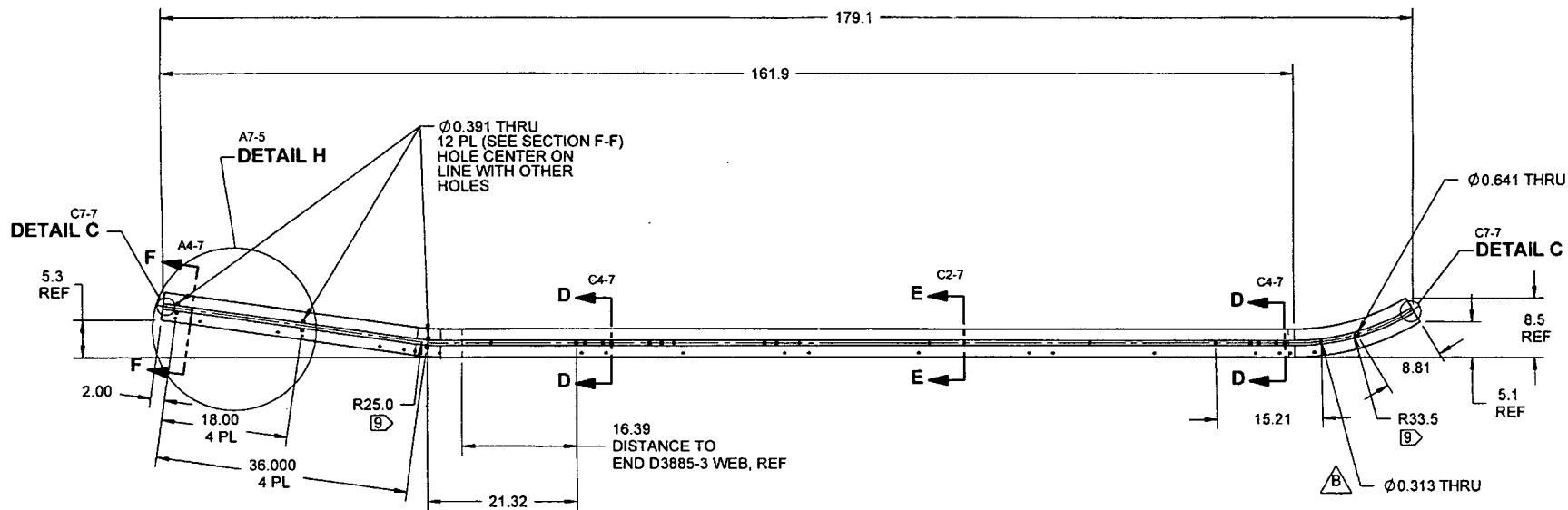
**D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE**  
(MAKE FROM D3905-13 SKIDTUBE)

RELEASED  
27/07/15 M4

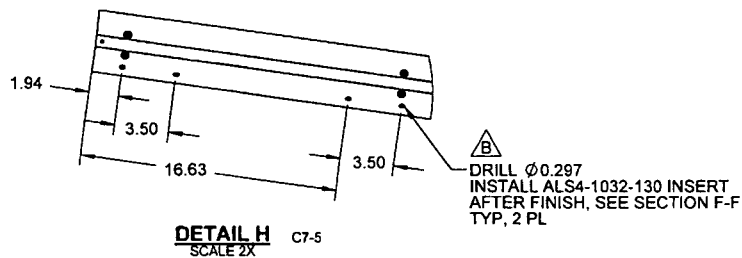
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**D3905-11 FLOAT SKIDTUBE**  
(MAKE FROM D3905-1 TUBE)



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8 7 6 5 4 3 2 1

A7-6  
DETAIL G

C7-7  
DETAIL C

5.3  
REF

2.00

18.00  
4 PL

36.00  
4 PL

R25.0

21.32

16.39  
DISTANCE TO  
END D3885-3 WEB, REF

179.1

161.9

D C4-7

D

E C2-7

E

D C4-7

D

15.21

R33.5

B

Ø0.313 THRU

Ø0.641 THRU

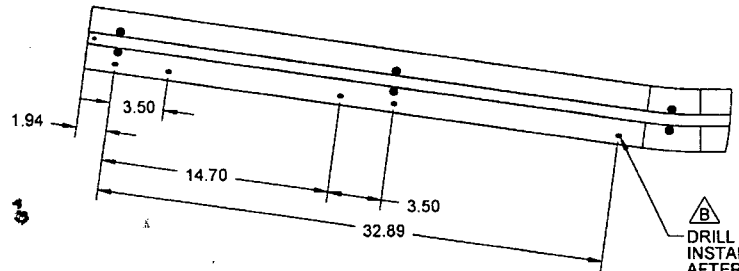
C7-7  
DETAIL C

8.5  
REF

8.81

5.1  
REF

**D3905-13 FLOAT SKIDTUBE**  
(MAKE FROM D3905-1 TUBE)



**DETAIL G**  
SCALE 2X C8-6

DRILL Ø0.297  
INSTALL ALS4-1032-130 INSERT  
AFTER FINISH, SEE SECTION F-F  
TYP. 2 PL

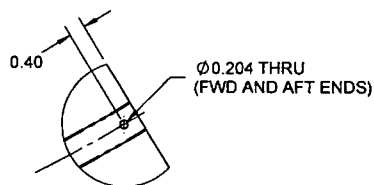
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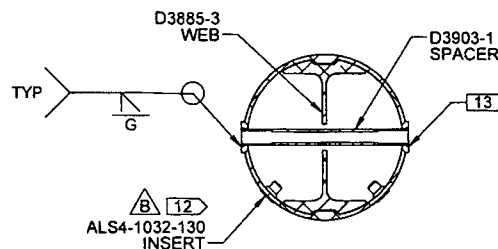
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8 7 6 5 4 3 2 1



**DETAIL C**  
SCALE 4X

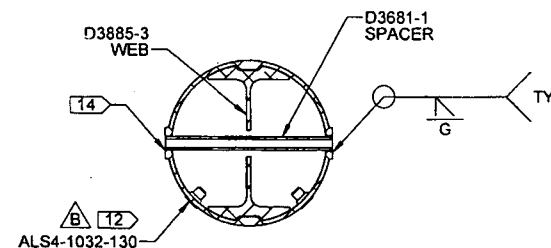
C1-5  
C8-5  
C8-6  
C1-6



**SECTION D-D**  
SCALE 4X

(FOR 12 x Ø 0.375 HOLES  
PER SKIDTUBE)

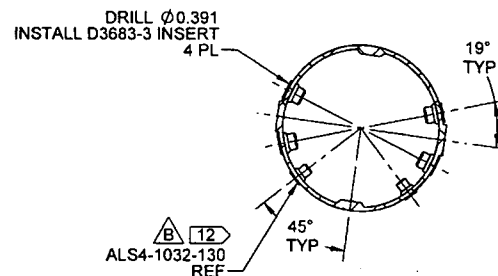
C5-5  
C2-5  
C5-6  
C2-6



**SECTION E-E**  
SCALE 4X

(FOR 8 x Ø 0.313 HOLES  
PER SKIDTUBE)

C4-5  
C4-6



**SECTION F-F**  
SCALE 4X

C7-6  
C7-5

**NOTES:**

13) AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø 0.375 HOLES ONLY:

- i) CHAMFER HOLES Ø 0.475 x 45° (BOTH SIDES)
- ii) INSERT D3903-1 SPACER
- iii) WELD INTO PLACE AND GRIND FLUSH
- iv) C'BORE TO 0.313 x 0.75 DEEP
- v) DEBURR HOLES




14) AFTER DRILLING AND BENDING ASSEMBLY

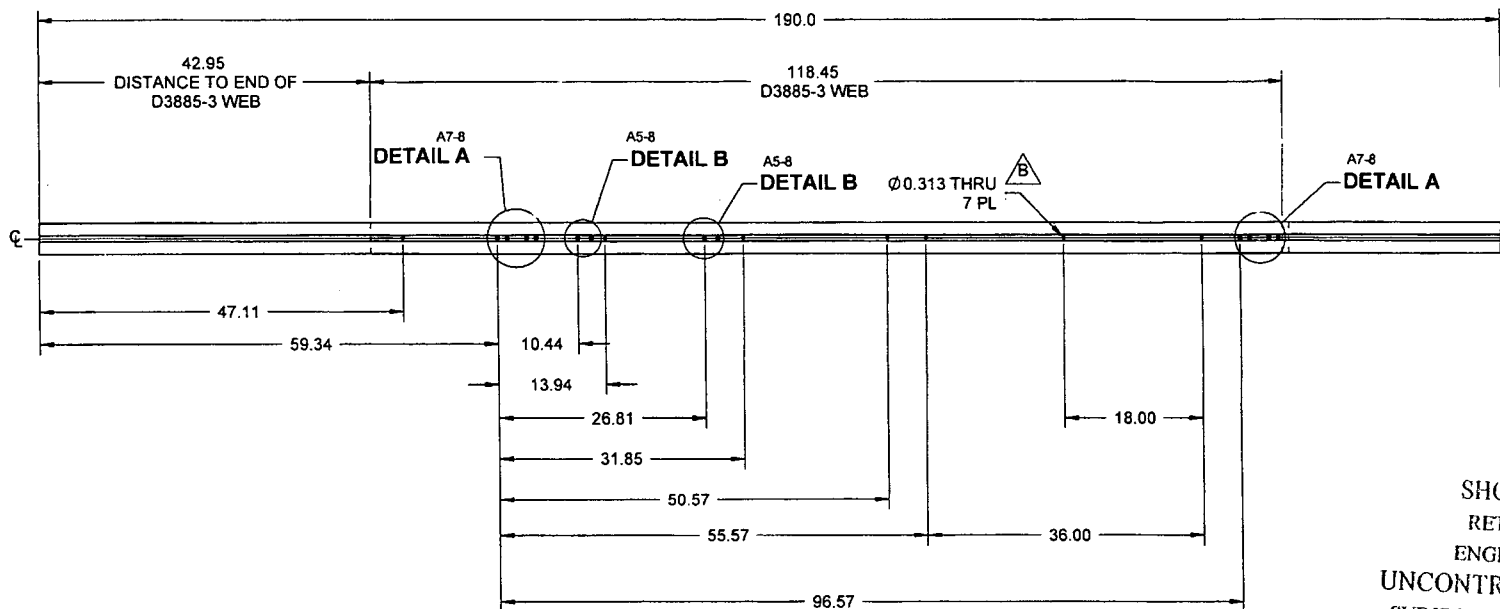
PERFORM THE FOLLOWING FOR Ø 0.313 HOLES ONLY:

- vi) CHAMFER HOLES Ø 0.354 x 45° OR 0.050 DEEP x 45° (BOTH SIDES)
- vii) INSERT D3681-1 SPACER
- viii) WELD INTO PLACE AND GRIND FLUSH
- ix) DEBURR HOLES

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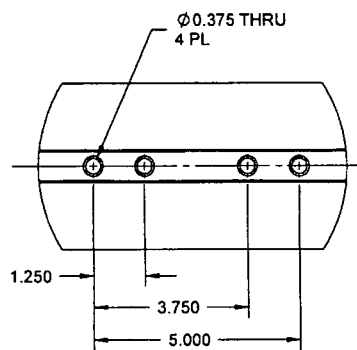
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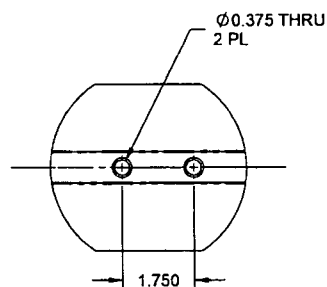
**D3905-1 TUBE**  
(MAKE FROM D2500-1-190 EXTRUSION)

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**DETAIL A**  
SCALE 4X  
D6-8  
D2-8



**DETAIL B**  
SCALE 4X  
D5-8  
D4-8

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9-10-20

B52976

REFERENCE ONLY

D119-646-243

09/11/06

Say 1  
(Skid)

- 1- impact Mat 1 D2500-1-190 per drawing
- 2- Ensure squareness of ends
- 3- Chemical conversion Cert as per Q51005/4.1

9-10-20

Say 2

QC 3/15

Permit

Say 3  
(Skid)

- 1- install drill rig DT9480 drill all back spacer holes using 3/16 Drill.
- 2- scribe batch # inside aft end of tube

9-10-21

Say 3  
(Board 1)

- 1- Band aft end of tube using CNC Bender 1 and bend prog D3905 Alt. 1 must use bending Aid DT9538 start to 3.25" from Alt.

9-10-21

REFERENCE ONLY

Say 4  
(Aid)

- 1- Ensure Bending Aid DT9538 is positioned correctly, that the bender is set up in on full wide and that the indexing ridge is covered with graphite grease.

- 1- Verify dimension of bend as per drawing
- 2- Buff out marks left from bending

- 3- Drill Alt. End Bore holes using DT9493 as per drawing D3905 detail G & Section F-F open to finished and

REFERENCE ONLY

4- DT — + DT as per dung D3905 detail 6

Open to finished size

3- Open X-belt spacer holes to finished size as per dung 3905 (action D-D & E-E) \*\*\* DO NOT OPEN FWD SADDLE HOLES \*\*\*

4- Debur, blowout chips from inside of tube

5- Bond web in place as per dung D3905 + OS 1015. Adhere per 12 hrs.

Sika 111A391

EXP Date 2010/02/30

Date 2/10/22

Time 9 AM

9-10-22

Sag 3  
(Bond 1)

1- Bond Fwd end of tube using bonds 1 and bond prog D3905 FWD. See Bonding Aid DT

Envelope positioning

2- Cut Fwd end of tube as per dung D3905 \*\*\* Verify measurement before cutting \*\*\*

9-11-15

Sag 4  
(Skid)

1- Buff out marks left from bending

2- Drill Fwd Cop holes using DT 8215 Open Fwd + Aft Cop holes to Ø 00208

3- Open Fwd saddle holes to finished size as per dung D3905

4- Drill Fwd X-belt hole + Open to finished size (hole must be drilled out manually)

9-11-15

REFERENCE ONLY

REFERENCE ONLY

11/11/6

5 - Drill four ring hole & open to finished size (holes must be laid out manually)

7 - Debur, blow out chips from inside of tube

6 - Open Alt flat bag holes  $\phi 0.391$  as per drawing D3905 detail G & Section F-F  
QC 5/6 (see note)

Sag 7

Sag 8  
(shid)

1 - Counter sink x-bolt holes as per drawing D3905  
2 - Remove slotline prepare for welding

3 - insert x-bolt spacers  
BE 09/11/6

4 - weld x-bolt spacers  
A/R M112507

5 - grind welds flush

6 - C' base x-bolt holes as per drawing D3905  
9-11-16

7 - Debur

REFERENCE ONLY

Sag 9 QC 5/6 see w/d

Sag 10 QC 10 see w/d

Sag 11 PAINT

NO. 217

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barday Elliott  
Job number: 52996  
Part number: D119-646-243  
Description: 11" skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Lat. Dymal Date of Test Coupon 09.11.16

Welder Barday Elliott Date of Test Coupon 09.11.16

The above named individual is qualified in accordance with AWS D17.1.2001 to weld